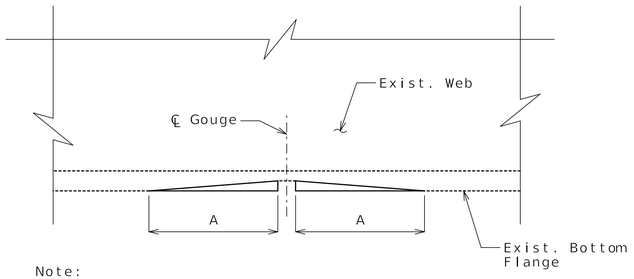
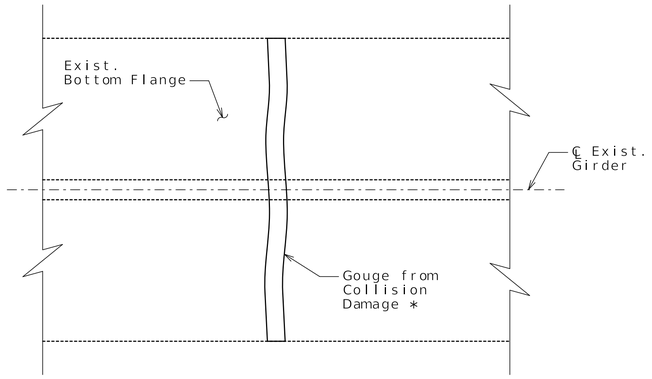
GOUGE REPAIR TYPE 1



Note:
Repairs by grinding shall have edges flared to the flange surface with a slope not exceeding 1 in 10.

GRIND DETAIL FOR FLANGE

DEPTH	A
$< \frac{3}{16}$"	$1\frac{7}{8}$"



PLAN OF GOUGE COLLISION DAMAGE

EVALUATION OF FLANGE GOUGE REPAIRS

If the length of gouge is less than or equal to 2 inches and depth of the gouge is 1/16 inch or less, then no repair is necessary.

If the length of the gouge is greater than 2 inches and the depth of the gouge is 3/16 inch or less, then use Gouge Repair Type 1.

If the depth of the gouge is greater than 3/16 inch, then use Gouge Repair Type 2.

Payment for girder gouge repairs will be completely covered by Grind Surface Deformities. See Special Provisions.

* The girder bottom flange shall be repaired for gouging resulting from collision damage as directed by the Engineer. The Contractor shall not perform any repairs until the defects have been reviewed and categorized as Type 1 or Type 2 by the Engineer.

4 Deleted

4 notify the engineer of record for further repair measures.

GOUGE REPAIR TYPE 2

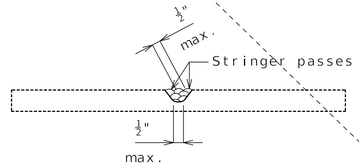
Note:

Type 2 repairs shall consist of welding the gouge and grinding it smooth at the Engineer's discretion prior to coating. Welding shall be in accordance with AWS D1.5 standards.

WELD NOTES

All welds shall be made using 1/8" or 5/32" E7018 electrodes only (Not E7028).

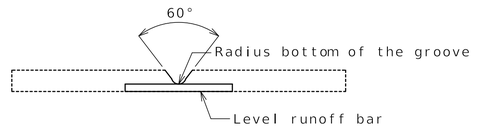
Maximum weld size shall be 1/2" across the face of the weld on each pass. Stringer passes shall be used to achieve this dimension.



Preheat shall be 250°F min. prior to any tacking or welding.

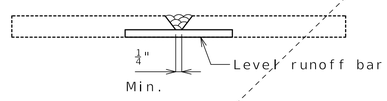
All runoff bars and weld backing bars shall be 1/4" x 1 1/2" flat bar minimum, and shall extend 2" beyond the edge of the flange.

The groove welds shall have a min. of 60° inclined angle.



All welds shall be started 1" out on the runoff bar and continued toward the center of the flange. Runoff bars shall be level with the bottom of the groove.

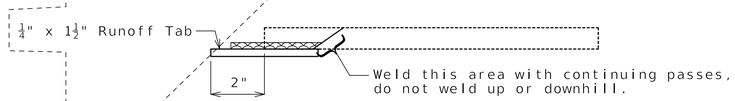
100% penetration welds shall have a min. 1/4" root opening and all welding shall be done from the top side.



All runoff bars shall be burned off 1/8" min. beyond the edge of the flange and ground flush.

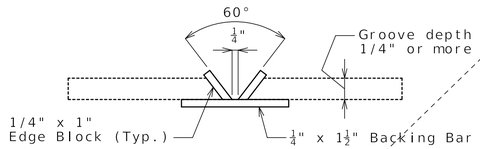
All 100% groove weld backing bars shall be torched or arc gouged off to within 1/8" of the flange and then ground smooth. The bottom of the flange shall be ground smooth after welding.

All welds shall be made in the flat position with no welding up or down on incline slope.



Use 1/4" x 1" flat bar to support the edge of welds that are layered, anytime the groove depth exceeds 1/4".

GOUGE REPAIR TYPE 2 (CONT.)



Edge blocks shall extend 2" from edge of flange, and be removed after welding in the same manner as the backing bar. All welds shall be ground smooth.

Notes:

All Type 2 Repairs to girder flanges shall be Q.C. inspected by ultra-sonic testing. Acceptance or rejection of the repair welds shall be based on the requirements of Table 9.2 of AWS D1.5-95.

Welders shall be AWS Certified for overhead welding.

4 Deleted

GOUGE REPAIR DETAILS

Detailed June 2026
Checked June 2026

Note: This drawing is not to scale. Follow dimensions.

4 9/14/26

STATE OF MISSOURI
TRENTON B. CRAWFORD
NUMBER PE-2012018053
PROFESSIONAL ENGINEER
THIS SHEET HAS BEEN SIGNED, SEALED AND DATED ELECTRONICALLY.

DATE PREPARED 9/14/2026

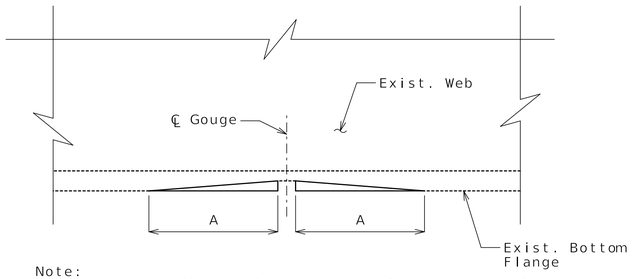
ROUTE	STATE
I-70	MO
DISTRICT	SHEET NO.
BR	3

COUNTY ST. CHARLES
JOB NO. JSL0305
CONTRACT ID.
PROJECT NO.
BRIDGE NO. A35825

DESCRIPTION | DATE

MISSOURI HIGHWAYS AND TRANSPORTATION COMMISSION
105 WEST CAPITOL
JEFFERSON CITY, MO 65102
1-888-ASK-MODOT (1-888-275-6636)

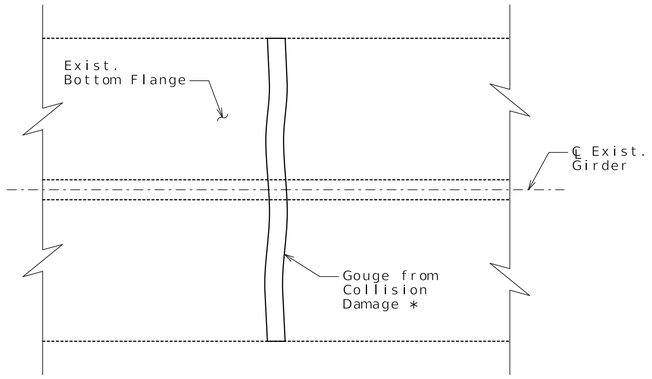
GOUGE REPAIR TYPE 1



Note:
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GRIND DETAIL FOR FLANGE

DEPTH	A
$< \frac{3}{16}$"	$1\frac{7}{8}$"



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GOUGE REPAIR TYPE 2

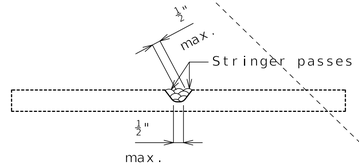
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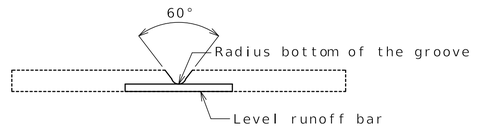
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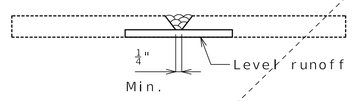
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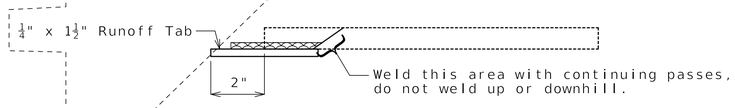
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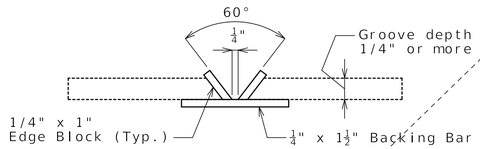
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GOUGE REPAIR DETAILS

Detailed June 2026
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